

Date:  
User:Thursday, 9/14/2006 7:30:34 AM  
Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BAFFLE & DEFLECTOR ASSEMBLY
<b>Job Number</b> : 28581	
<b>Estimate Number</b> : 12223	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3467049
<b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3467 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 26976	<b>Material</b> : N/A
<b>Written By</b> : <u>JA 06 09 14</u>	<b>Due Date</b> : 10/6/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JA 06 09 14</u>	
<b>Comment</b> : Est Rev: A New Issue 06-04-24 JLM Est Rev:B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D346715	DEFLECTOR
-----	---------	-----------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3467-15 Deflector B 28592

mf. 06/09/28. (8)

2.0	D346713	BAFFLE
-----	---------	--------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-13 Baffle B 2610 x 2mx

B 28591 - 2mx mf. 06/09/28. (4)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

mf. 06/09/28. (4)

2-Spot Weld as per Dwg D3467 and Dart QSI 004

mf. 06/09/28. (4)

4.0	QC5/11	INSPECT WORK/INSPECT SPOT WELD
-----	--------	--------------------------------

**Comment:** INSPECT WORK/INSPECT SPOT WELD

SB 06/10/02 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/10/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:30:34 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE & DEFLECTOR ASSEMBLY

Job Number: 28581

Part Number: D3467049

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57439

GA

TOOK

①

06/10/02 (y)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 06/10/03

①

Job Completion



U 86-10-03

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

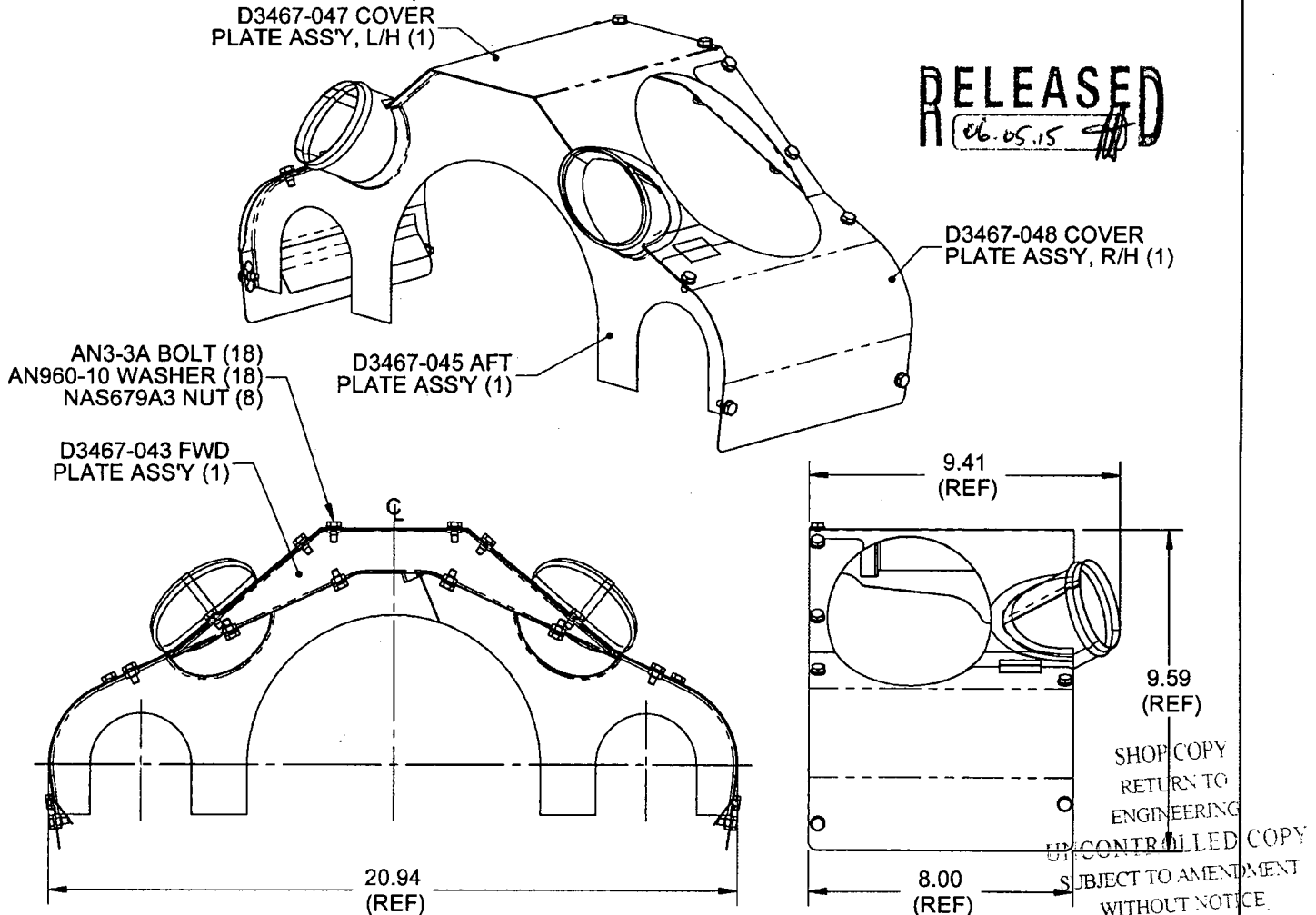
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3467</b>	REV. B SHEET 1 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:5
A.	05.12.07	NEW ISSUE	
B.	06.05.15	$\phi 0.250$ & $\phi 0.203$ WERE $\phi 0.194$ ; UPDATED D3467-9F/-15F	



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

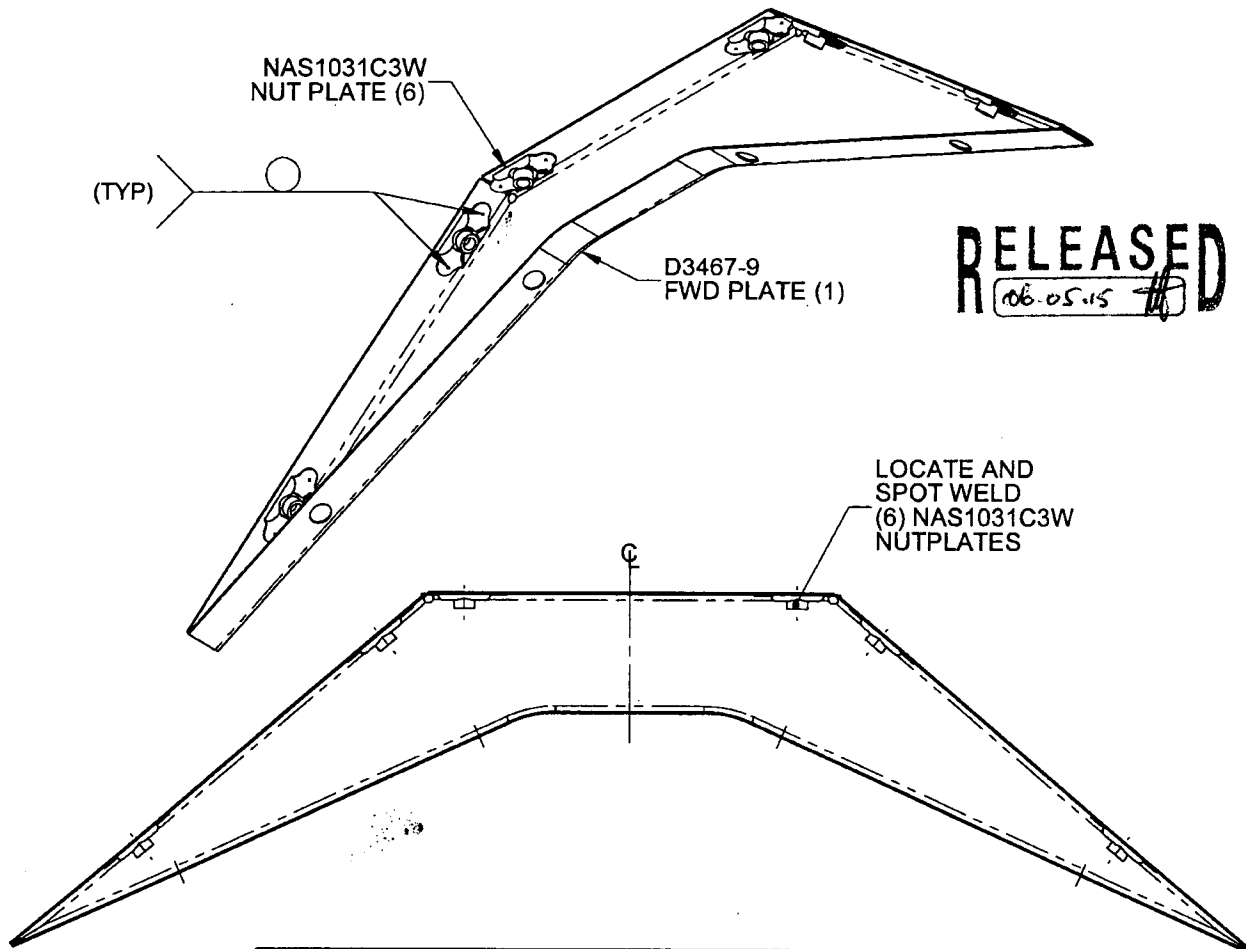
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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CHECKED #	APPROVED #	DRAWING NO. <b>D3467</b>	REV. B SHEET 2 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

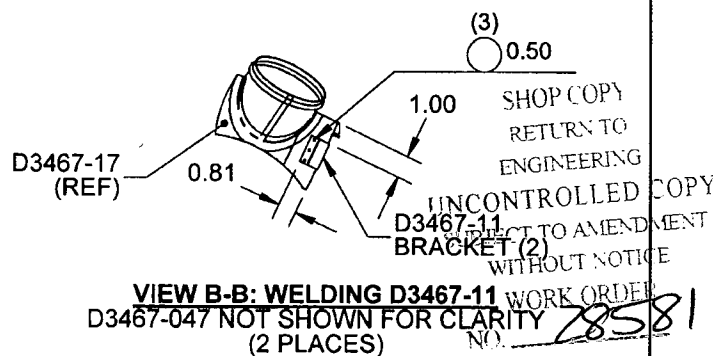
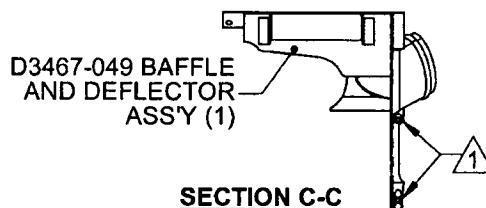
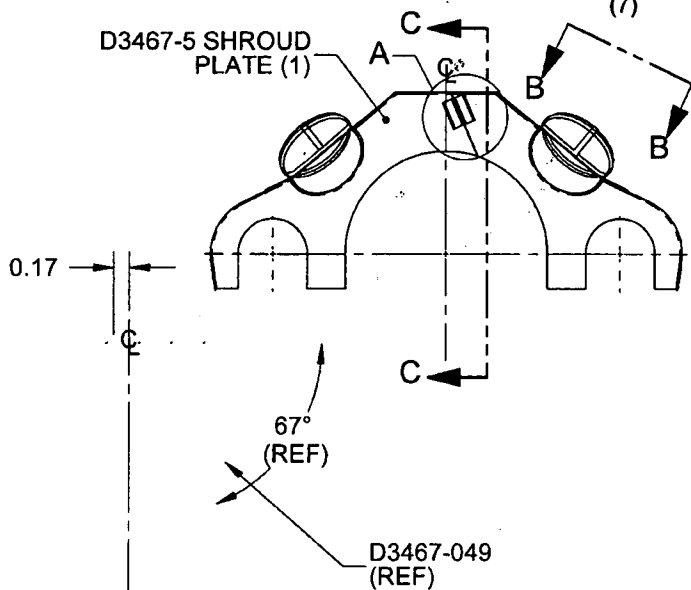
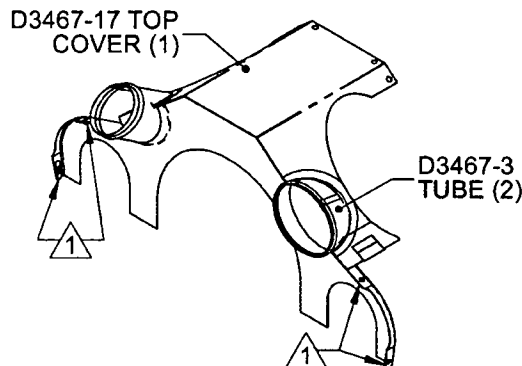
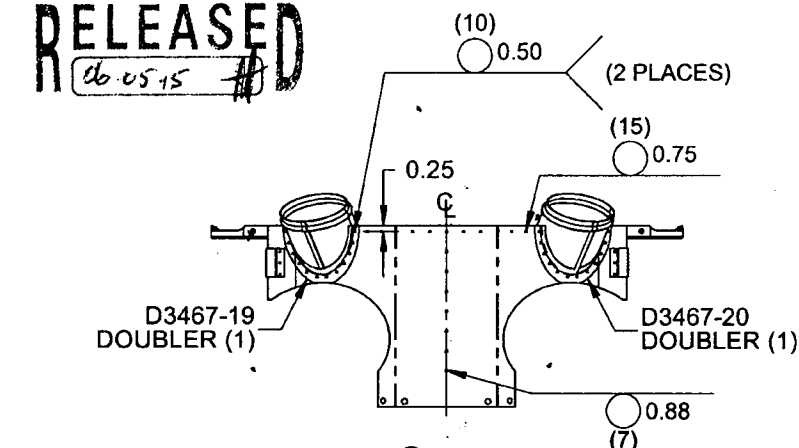
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DATE 06.05.15		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8

**RELEASED**  
06.05.15**DETAIL A**  
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

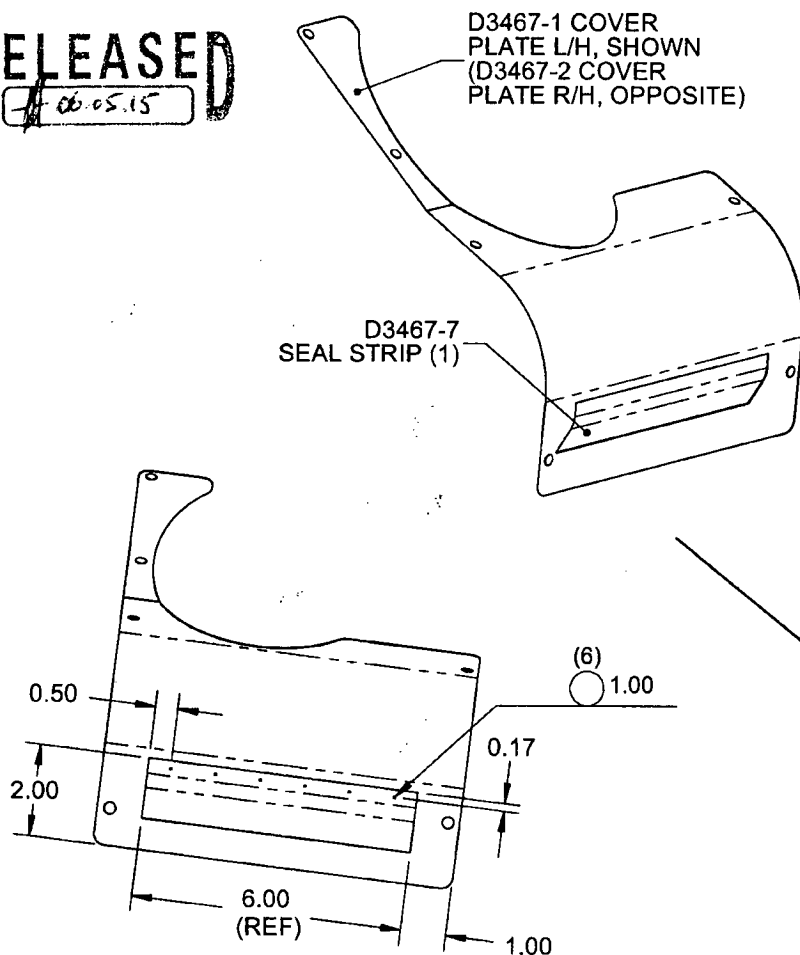
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 4 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**RELEASED**  
06.05.15



**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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NO. 2858

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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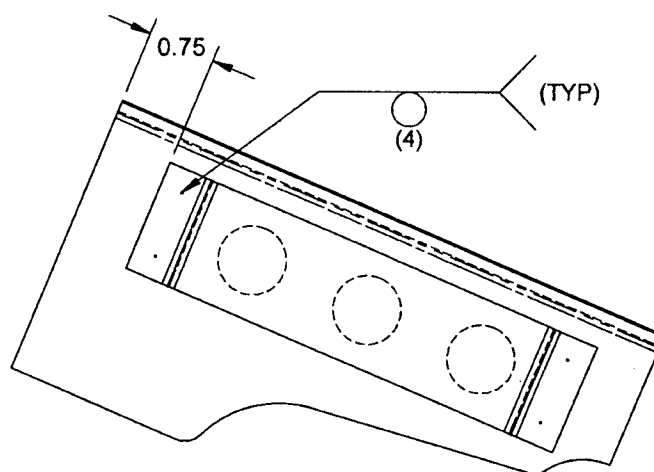
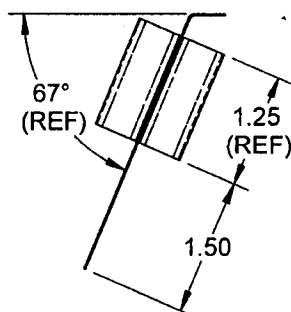
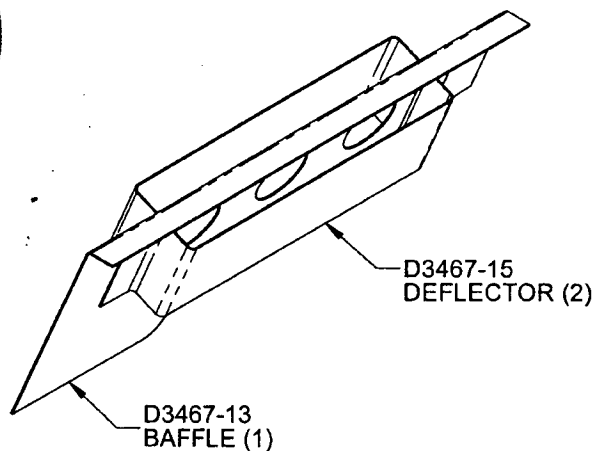






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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

RELEASED  
06.05.15



**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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NO. **28581**

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

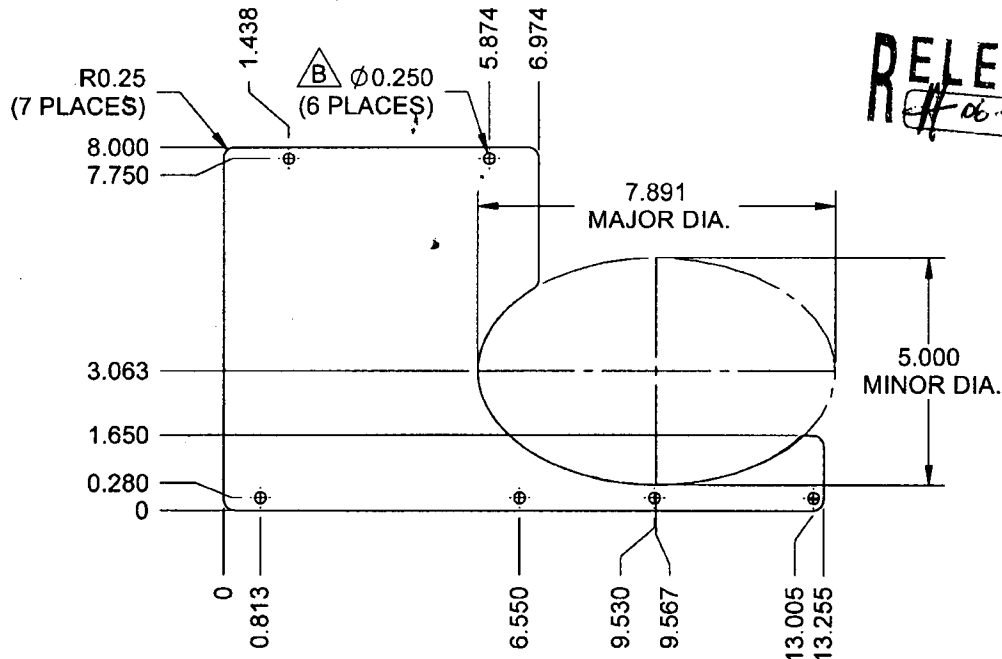
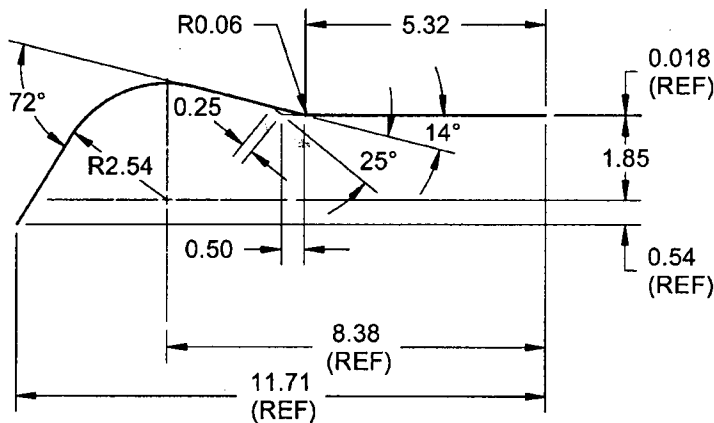
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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CHECKED H	APPROVED H	DRAWING NO. <b>D3467</b>	REV. B SHEET 6 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE  
D3467-2 R/H COVER PLATE (OPPOSITE)****D3467-1 L/H COVER PLATE ISOMETRIC VIEW.  
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8 RETURN TO

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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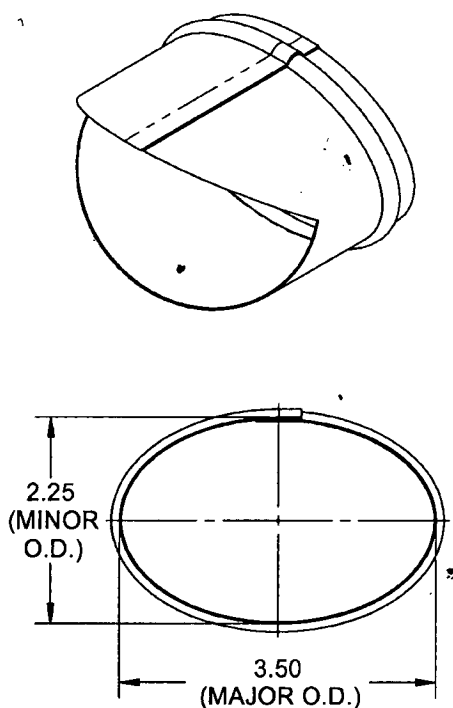
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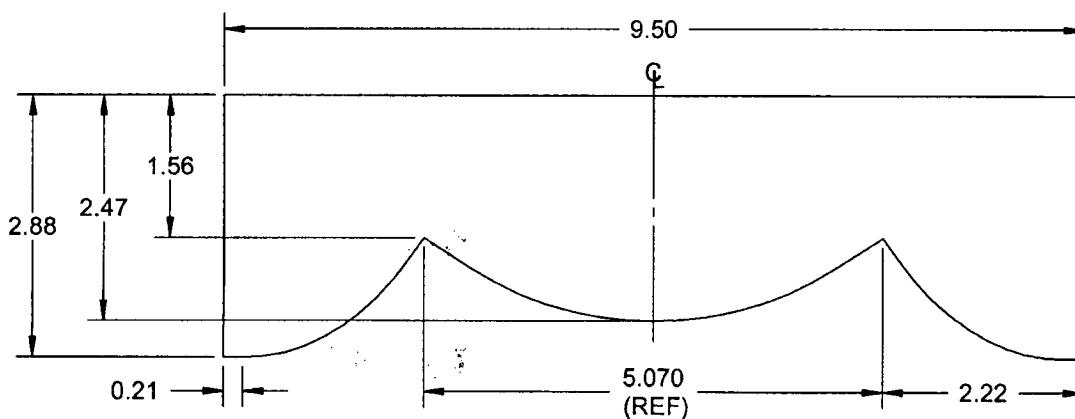
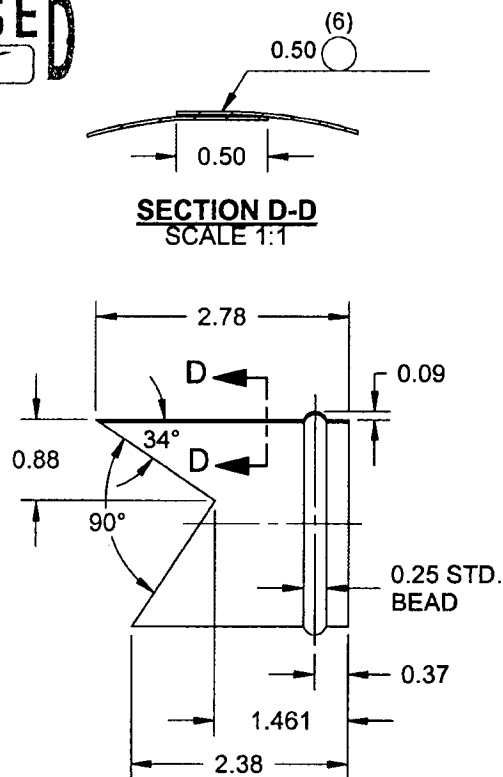


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CHECKED #	APPROVED #	DRAWING NO. <b>D3467</b>	REV. B SHEET 7 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

RELEASED  
# 06.05.15



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

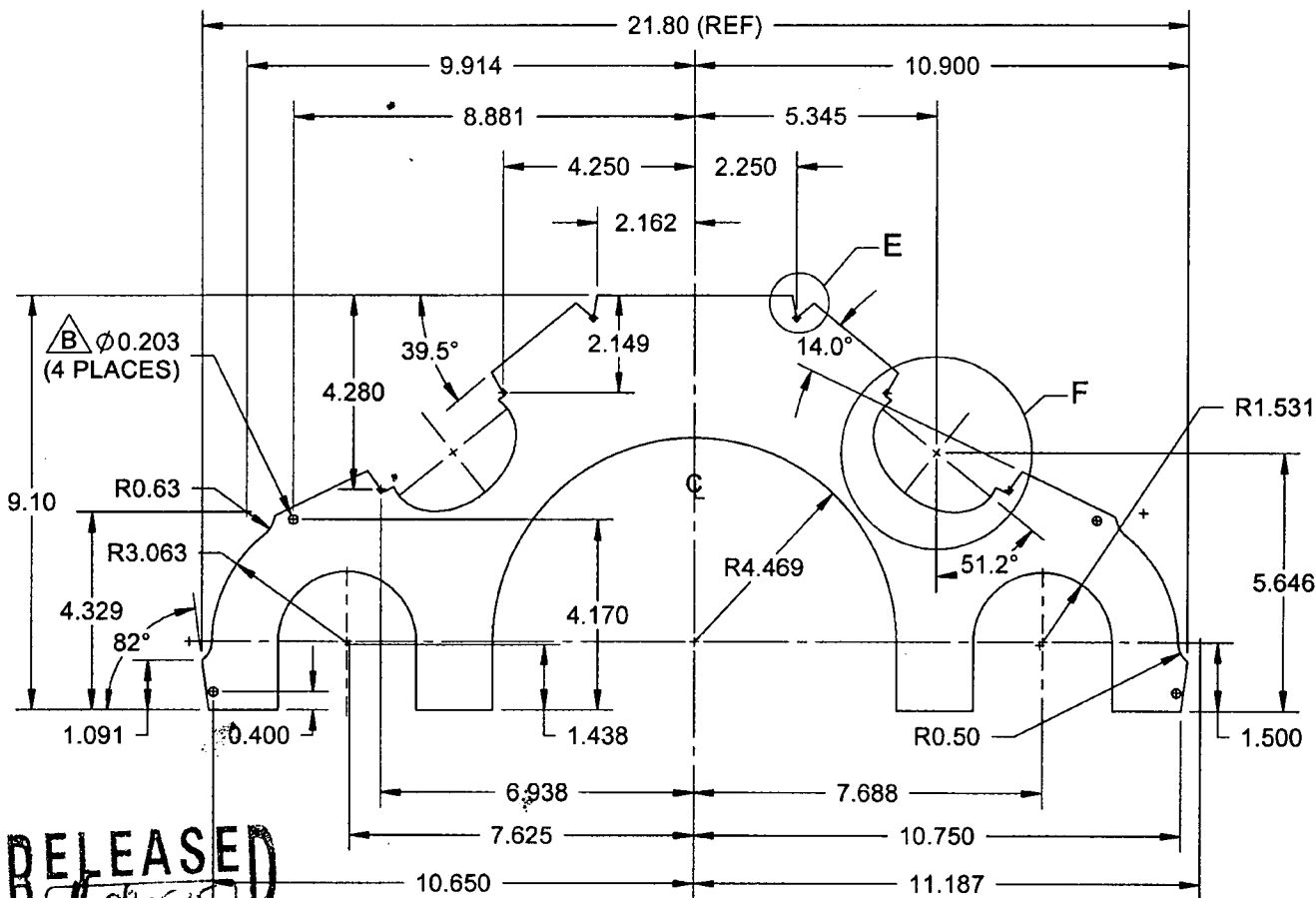
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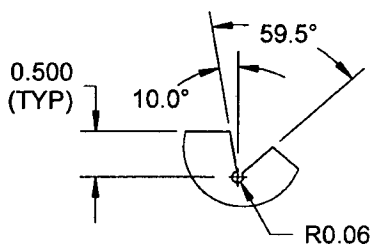
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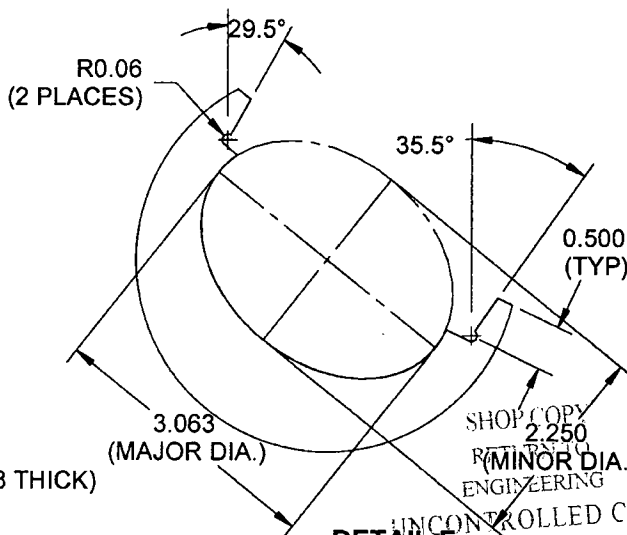
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CHECKED #13	APPROVED #13	DRAWING NO. <b>D3467</b>	REV. B SHEET 8 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



**RELEASED**  
#06-05-15



**DETAIL E**  
SCALE 1:2



**DETAIL F**  
SCALE 1:2  
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WORK ORDER  
NO 28581

### D3467-5F AFT PLATE FLAT PATTERN

#### NOTES:

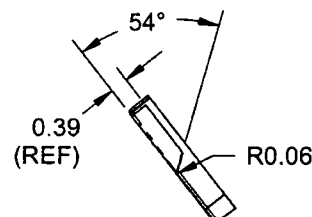
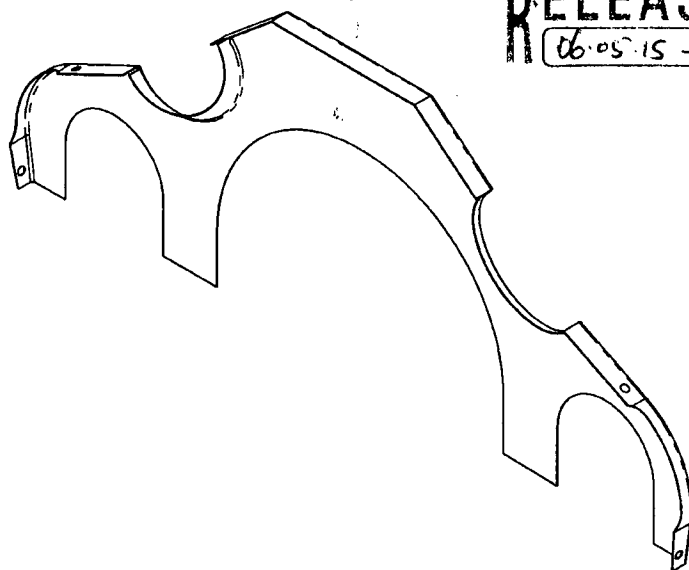
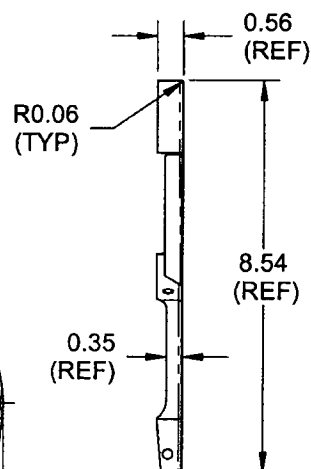
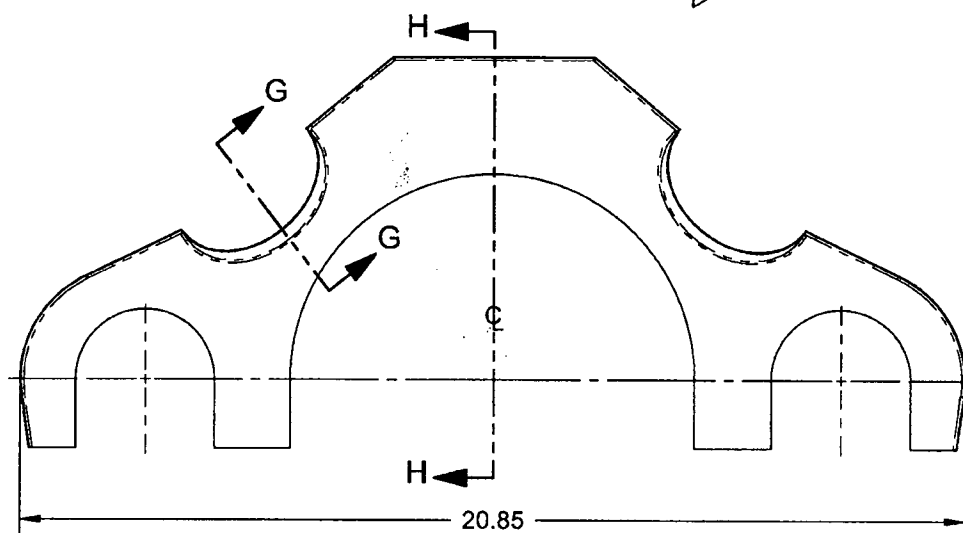
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**RELEASED**  
06.05.15**SECTION G-G****SECTION H-H****D3467-5 AFT PLATE BENDING DETAIL****NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

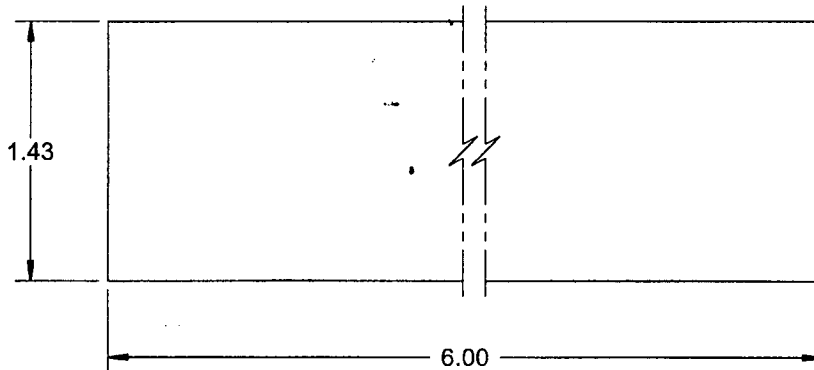
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NO. 28581

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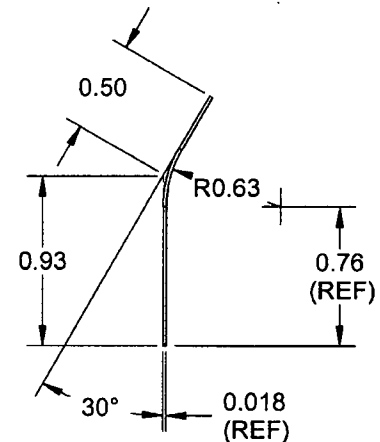
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**DART**

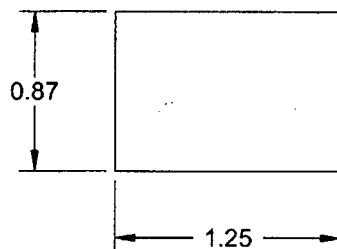
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 10 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:1

**RELEASED**  
*06-05-15*

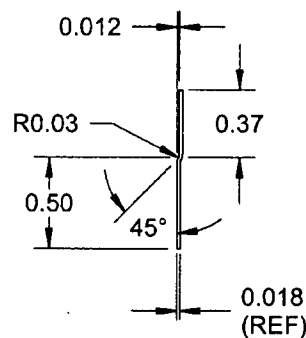
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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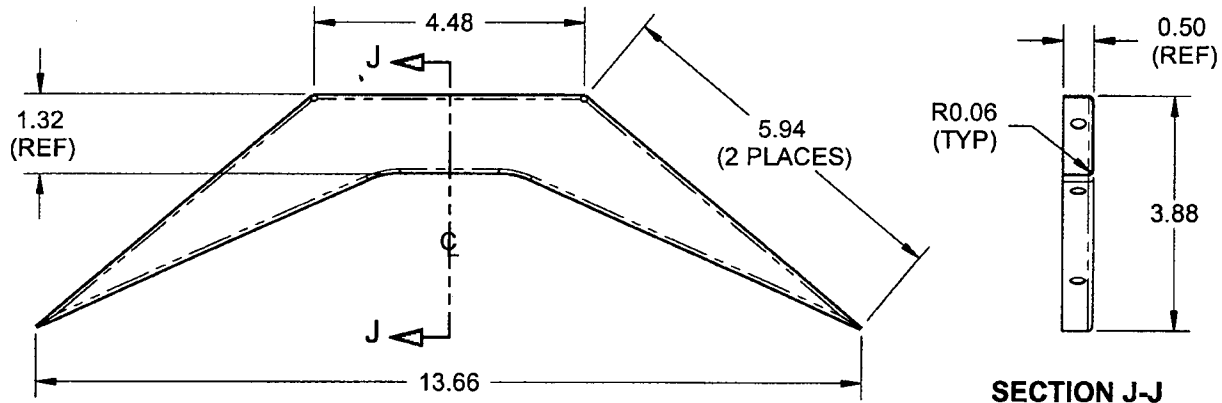
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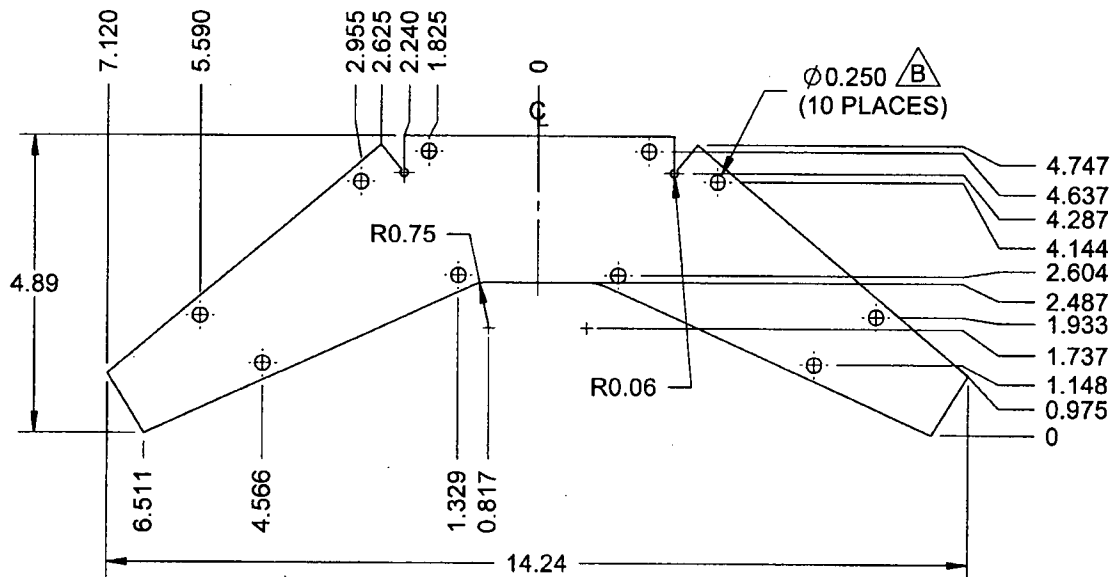


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 11 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:3

**RELEASED**  
*[Signature]* 06.05.15



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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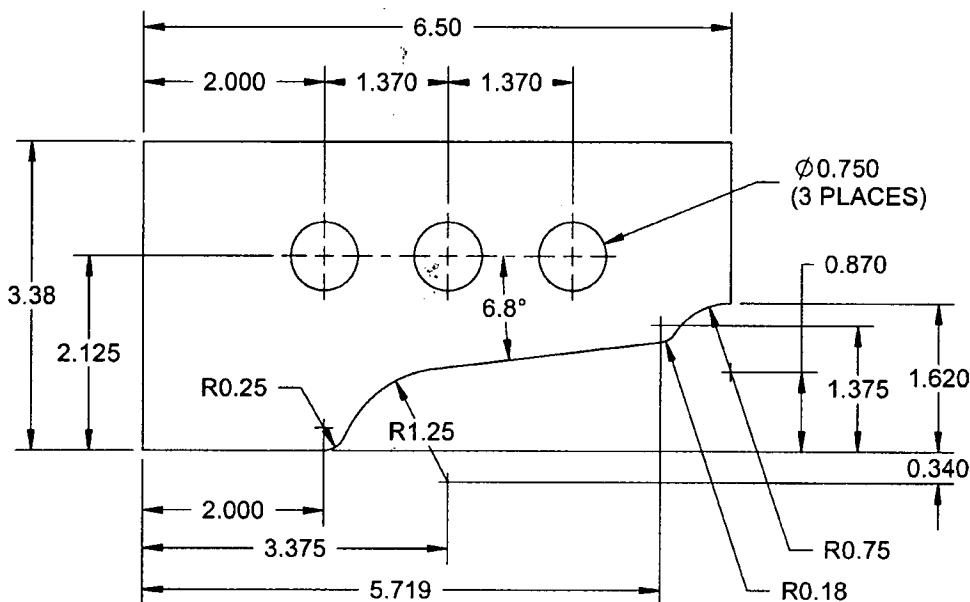
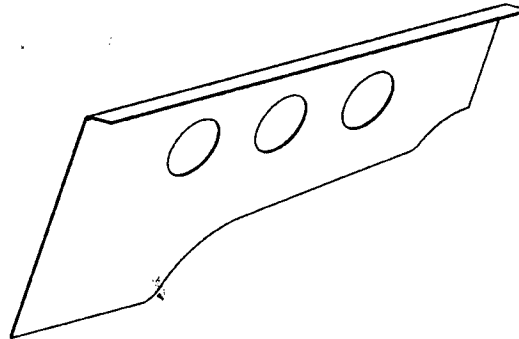
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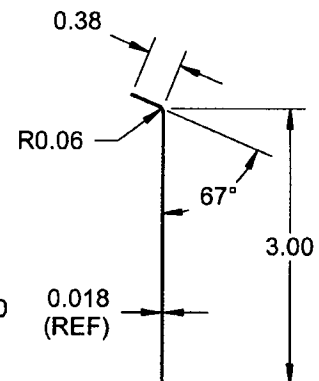


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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# 06-05-15



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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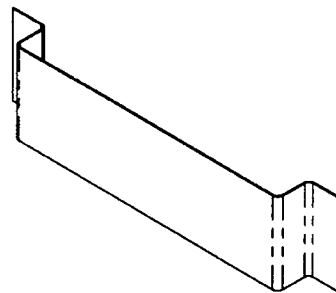
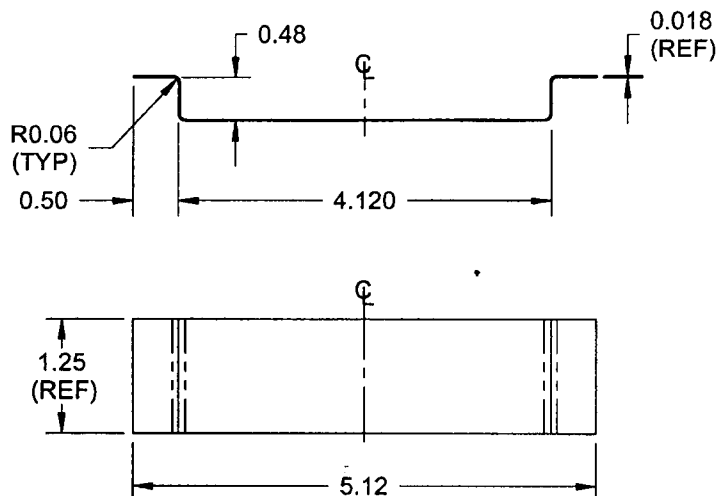
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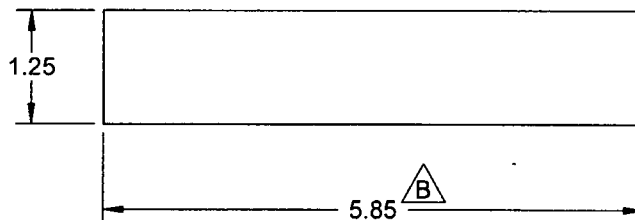


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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06.05.15



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

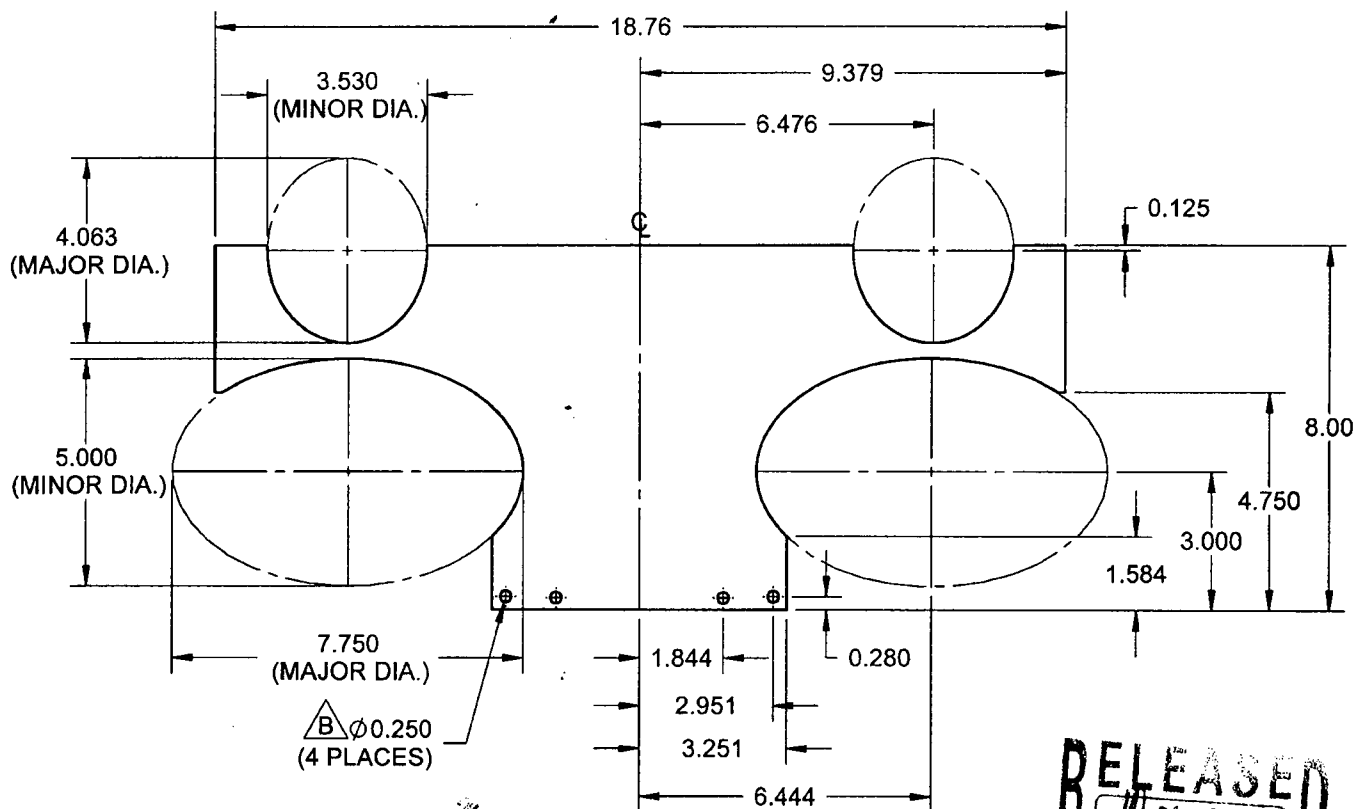
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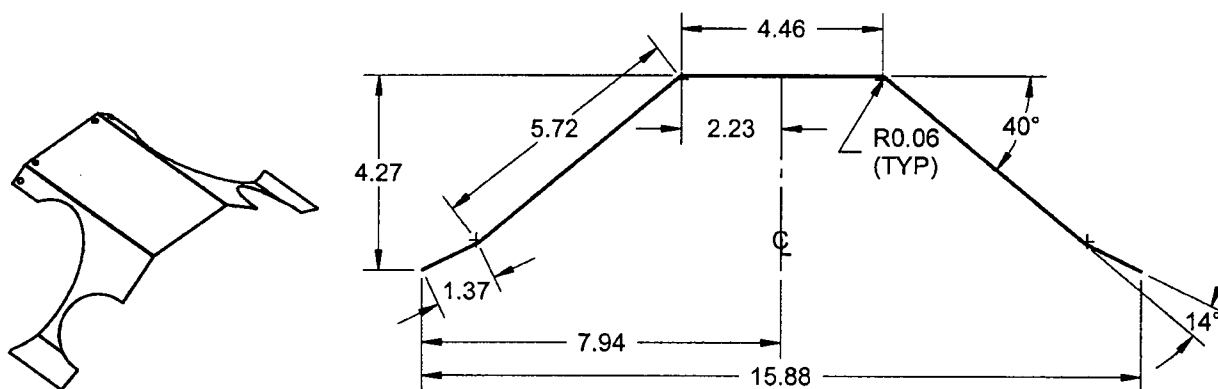


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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**

**RELEASED**  
#06-05-15



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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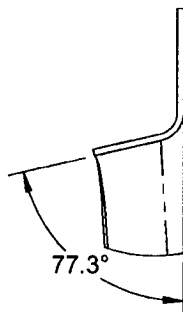
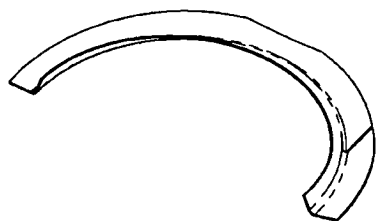
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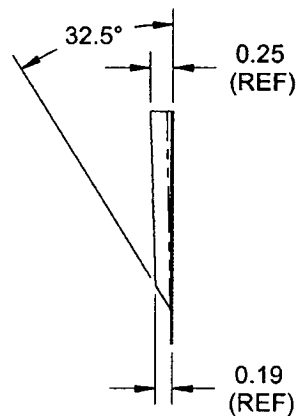
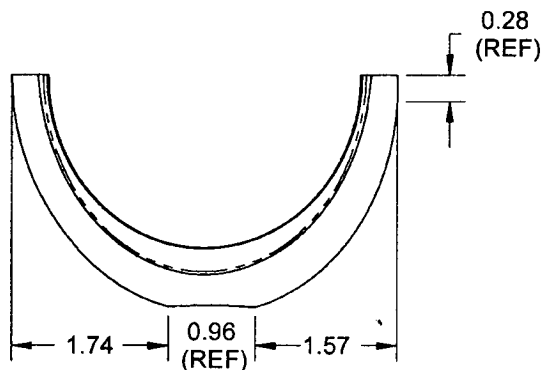
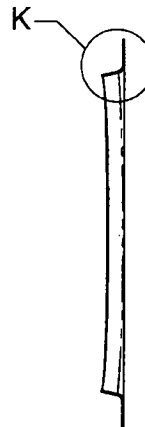


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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

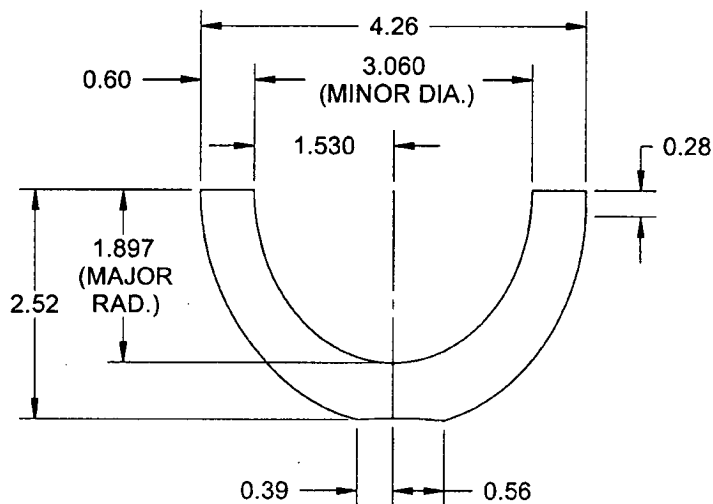
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**DETAIL K**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



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**D3467-19F FLAT PATTERN**

WORK ORDER  
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**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 14

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Melanie Fauteux

Joint Welding Procedure Spot Welding

Part number and Job number D 3467-049 B 28581 GTx 4

TEST WELDS REQUIRED

BASE METAL 304 2G WELDING PROCESS Spot  
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

*W/A*

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ *W/A*

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/02 Qualifier Sylvie Boucher